

Work Order ID 121872

121872

Page 1

Wednesday, July 02, 2014 3:37:47 PM

Item ID: \ D2694 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pod , 350/407
 Start Date: 7/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: CL Date: 14/07/03 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2694	Rev I

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

*** QTY of (3) D3001-1 Ship to Delastek ***

Issue P/O: 24876

Description:

D2202-1Pod Lid

D2202-3Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

CL 14/07/04 (1)

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure certificate of conformity and process sheet from Delastek is attached

IX SP 14-8-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 121872

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Page 2

Item ID: D2694 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pod , 350/407
Start Date: 7/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/02/14 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Check for void spot and pins. Check over all dimensions as per Dwg D2202.

① 1408-21 AD

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Drill hinge, Lid and base as per dwg D2694

DAS
27
9-89

14/10/30

PTC

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

① 14-10-30

DAS
9
9-89

DQA:

Date: 14/12/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/12/10

Work Order update only ☐

Work Order: <u>121872</u> Part No. <u>D2694</u> NCR No. <u>14-4448</u> Supplier NCR <u>14-4451</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input checked="" type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input checked="" type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design	14.10.12	130	①	holes in upper bracket of D2204.9 was off set part as not bend properly	DAS 16 9-89 Q52042	Replace Scrap + destroy D2204.9 B115468 and replace with new one D2204.9 B115468	DAS 27 9-89 14/11/12	DAS 9 9-89 14.11.03	L 1 9-89 Q52042 14/11/12		
Doc/Data						-QC check at all D2204.9 B115468 as per drawing.	DAS 38 9-89				
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input checked="" type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
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<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other
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Work Order ID 121872

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Page 3

Item ID: D2694 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pod , 350/407
Start Date: 7/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00				DAS 27 9-89			
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2694 Use DT8023 for (10) holes on base. 2- install placard as per dwg								
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									

DAS
96
9-89

NOV 05 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 121872***121872***

Page 4

Item ID: D2694

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pod , 350/407

Start Date: 7/02/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/02/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14/11/6

mf
14-11-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

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Picklist Print

Wednesday, July 02, 2014 3:37:46 PM

Page 2

Work Order ID: 121872

121872

Parent Item: D2694

D2694

Parent Item Name: Pod , 350/407

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

D3001-1 Manufactured No

100 Each 9.0000 3 3

D3001-1

Doubler

**

CL 14/07/04

Location

Loc Qty

Loc Code

ST178

9

113456

7

99490

2

3

D2202-1P

Purchased No

110 Each 0.0000 1

D2202-1P

Side Pod Lid, 350

**

①

Sp 14-10-28

D2202-3P

Purchased No

110 Each 0.0000 1 1

D2202-3P

Side Pod Base, 350

**

Sp 14-10-28

D2204-9

Manufactured No

150 Each 19.0000 5 5

D2204-9

Rubber Latches

**

DAG 27 0-00 14/10/28

Location

Loc Qty

Loc Code

st238

19

107654

5

111010

9

113537

2

85081

3

B115468

⑤

D2569

Manufactured No

130 Each 4.0000 1 1

D2569

Hinge

**

Shp 14/10/28

Location

Loc Qty

Loc Code

CA

4

110818

2

113832

1

120533

1

B121865

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Wednesday, July 02, 2014 3:37:46 PM

Work Order ID: 121872

121872

Parent Item: D2694

D2694

Parent Item Name: Pod, 350/407

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

D2429-041

Manufactured No

150 Each 9.0000 1 1

D2429-041

Spring Clip Ass'Y

**

DAS
27
9-09
4/10/28

Location

Loc Qty

Loc Code

ST008

9

107585

6

81895

3

D2528-1

Manufactured No

150 Each 10.0000 5 5

D2528-1

Backer Plate

**

DAS
27
9-09
4/10/28

Location

Loc Qty

Loc Code

ST007

10

82334

10

B113711

D2528-3

Manufactured No

150 Each 4.0000 4 4

D2528-3

Backer Plate

**

DAS
27
9-09
4/10/28

Location

Loc Qty

Loc Code

ST007

4

107611

2

65085

2

B110938

D3007-041

Manufactured No

150 Each 2.0000 1 1

D3007-041

Prop Assy

**

DAS
27
9-09
4/10/28

Location

Loc Qty

Loc Code

ST259

2

107599

1

84300

1

B110916

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Wednesday, July 02, 2014 3:37:46 PM

Work Order ID: 121872

121872

Parent Item: D2694

D2694

Parent Item Name: Pod , 350/407

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

AD62ABS

Purchased

No

150

Each

249.0000

38

38

AD62ABS

rivet

7
8.89
14/10/14

Location

Loc Qty

Loc Code

st268

249

125293

7

m127048

42

m128211

100

m128454

100

m128211

38

AN4-5A

Purchased

No

150

Each

347.0000

19

19

AN4-5A

BOLT

DAS
27
8.89
14/10/14

Location

Loc Qty

Loc Code

ST355

347

120562

243

15247

4

m127817

100

19

AN4-6A

Purchased

No

150

Each

2,305.000

1

1

AN4-6A

BOLT

DAS
27
8.89
14/10/14

Location

Loc Qty

Loc Code

ST355

604

16067

4

M128403

600

ST514

1701

M126317

350

M128634

1351

1

1

1

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Wednesday, July 02, 2014 3:37:46 PM

Page 5

Work Order ID: 121872

121872

Parent Item: D2694

D2694

Parent Item Name: Pod , 350/407

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

AN526C632R7

Purchased

No

150

Each

201.0000

2

2

AN526C632R7

Screw

**

DAS
27
8-09
14/10/28

Location

Loc Qty

Loc Code

ST329

201

112385

1

m129339

200

NAS1149DN632J

Purchased

No

150

Each

454.0000

2

2

NAS1149DN632.J

Washer

**

DAS
27
8-09
14/10/28

Location

Loc Qty

Loc Code

ST277

454

M126084

11

M127255

100

M128812

343

NAS1149D0463J

Purchased

No

150

Each

7,578.000

21

21

NAS1149D0463.J

WASHER

**

DAS
27
8-09
14/10/28

Location

Loc Qty

Loc Code

ST277

7578

121912

12

16941

8

M126221

20

M127813

22

M127904

915

M128591

101

M128995

1500

M129390

5000

21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Qty	Part Number	Description
X	D2694	UTILITY POD ASSEMBLY
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2461-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET



CL 14/07/02

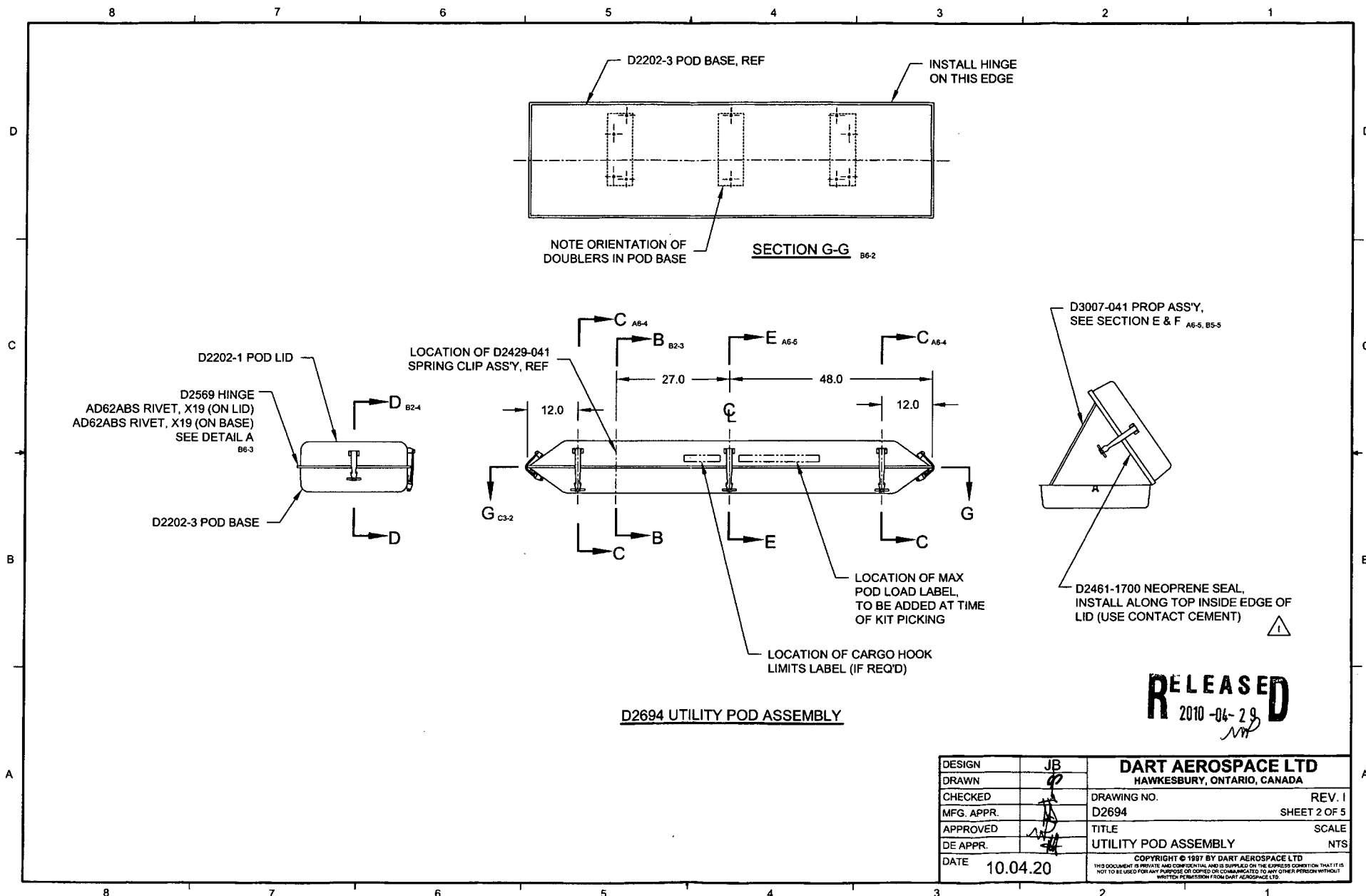
W/O. 121872

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER QSI 005 4.2 TO MATCH ORIGINAL FINISH
AS REQ'D TO TOUCH UP FINISH AFTER DRILLING OR ASSEMBLY
INSIDE: DUPONT HIGHBUILD PRIMER GREY 1144-S
OR DUPONT 2K-URETHANE PRIMER GREY 7704-S
OUTSIDE: DUPONT IMRON POLYURETHANE ENAMEL BASE WHITE (555U)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 48.5 lbs
- 8) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141
AN4 → DRILL Ø0.257
- 9) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- 10) FOR D2569 HINGE:
 - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD
 - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
 - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A

RELEASED
2010-04-29

I	REFORMAT, D2204-9 LOC SPEC'D (B2-4,B6-4,C2-4,C6-4, B6-5,C6-5), D2461-X WAS D2462-X (D5-1,B1-2), ADD FINISH (B5-1)	CP	10.04.20
H	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	DC	07.07.18
G	REVERT BACK TO D2204-9 LATCH	CP	01.05.08
F	REDESIGN, CHANGE LATCHES & PROP	CP	01.03.20
E	CHANGE DIMENSIONS	RF	99.12.20
D	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DEO9119	CP	99.01.08
C	ADD DOUBLER HOLES, REMOVE FINISH	KE	98.11.12
B	CHANGE RIVET PATTERN, ADD D2429	KE	97.10.08
A	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	KE	97.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2694 REV. 1 SHEET 1 OF 5 TITLE UTILITY POD ASSEMBLY SCALE NTS COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.20		



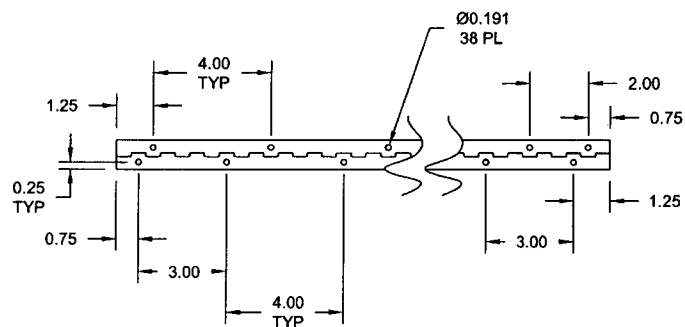
8 7 6 5 4 3 2 1

D

C

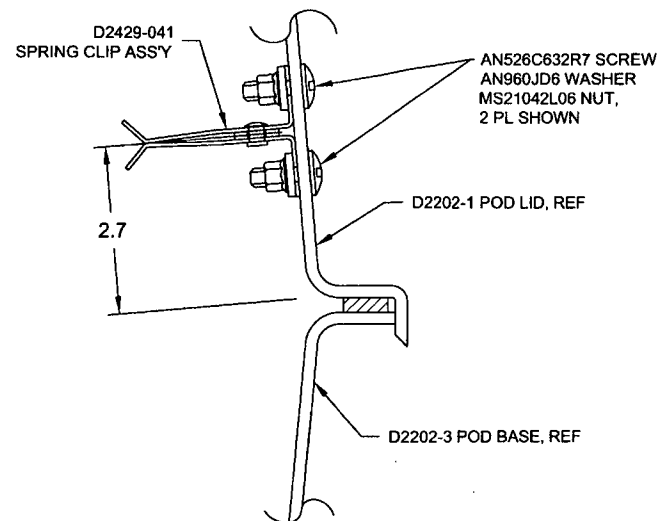
B

A



DETAIL A: HINGE
NOT TO SCALE

10
C7-2



SECTION B-B
NOT TO SCALE

C5-2

RELEASED
2010-04-29
mp

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. I
MFG. APPR.	JP	D2694	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

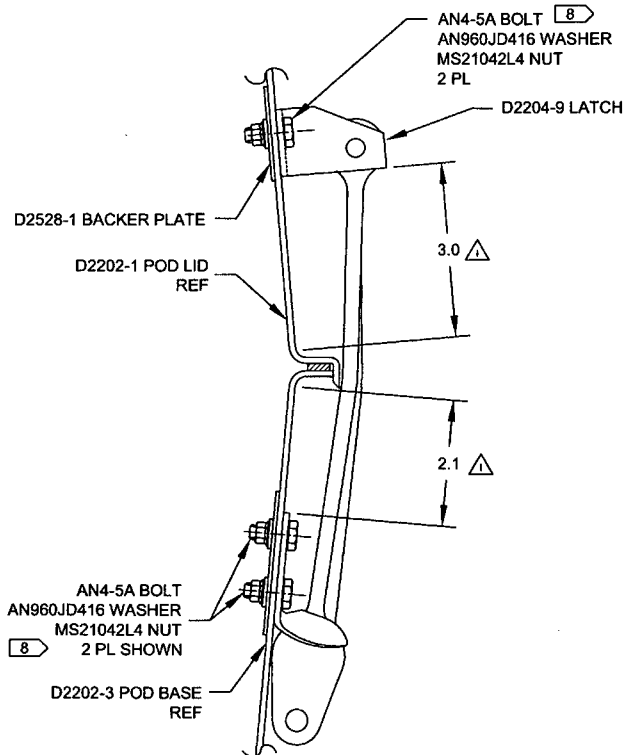
8 7 6 5 4 3 2 1

D

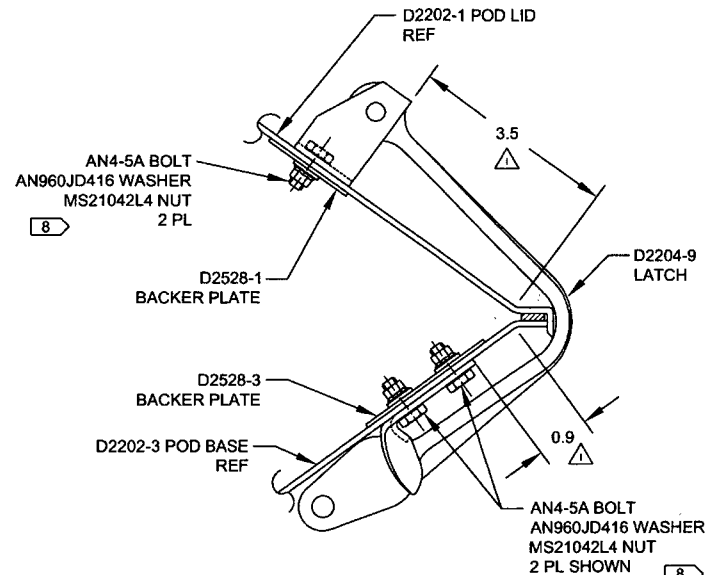
C

B

A



SECTION C-C C3-2, C5-2
SCALE 10X



SECTION D-D C6-2
SCALE 10X

RELEASED
2010-04-29
AMP

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO. D2694	REV. 1
MFG. APPR.	<i>JP</i>		SHEET 4 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D2202-1 POD LID, REF
D2528-1 BACKER PLATE
D2012-107 CLEVIS, REF

AN4-6A BOLT
AN960JD416 WASHER, 2X
MS21042L4 NUT
1 PL, BOLT HEAD ON INSIDE
OF POD AS SHOWN

D3007-1 PROP ARM
REF

AN4-10A BOLT, REF
D2022-101 SPACER, 2X REF
AN960JD416 WASHER, REF
MS21042L4 NUT, REF

AN4-5A BOLT
AN960JD416 WASHER
MS21042L4 NUT
1 PL, BOLT HEAD ON OUTSIDE
OF POD, NOT SHOWN

3.0

D2705 SUPPORT BRACKET
REF

AN4-5A BOLT
AN960JD416 WASHER
MS21042L4 NUT
2 PL SHOWN

2.1

F B2-5

D2204-9 LATCH

D2202-3 POD BASE
REF

SECTION E-E C4-2
SCALE 10X

B

A

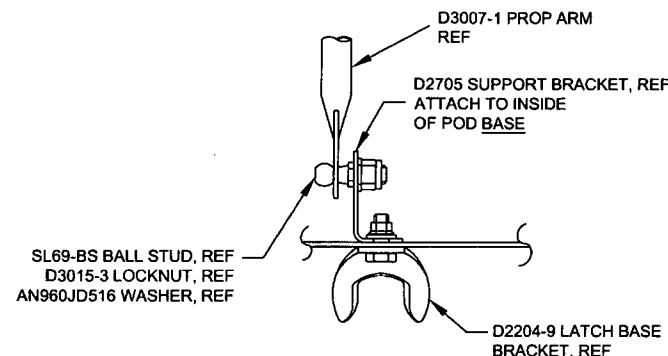
8 7 6 5 4 3 2 1

D

C

B

A



SECTION F-F B5-5
D3007-041 PROP ASSY DETAIL
SECTION ROTATED 85° CW

RELEASED
2010-04-29

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D2694	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1987 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24876**

Purchase Order Date 7/4/2014

PO Print Date 7/4/2014

Page Number 1 of 2

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							

1	D2202-1P	Side Pod Lid, 350	8/15/2014		1.00	\$2,890.60	\$2,890.60
			Yes		Each		
			8/15/2014				

AS PER DWG D2694 REV. G
B121872

Line Total: \$2,890.60

2	D2202-3P	Side Pod Base, 350	8/15/2014		1.00	\$2,890.60	\$2,890.60
			Yes		Each		
			8/15/2014				

AS PER DWG D2202 REV. G
B121872

8/14-8-18

Line Total: \$2,890.60

Note:

7/4/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	57986
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
15-08-2014	04-07-2014	24816	Chantal Lavoie	PO24876	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Jocelyne Laurin, 221			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073	Line #1 D2202-1 Side Pod Lid B121872 ✓ Référence DKA362-0015 DWG: REV. G Lot # 63009	U of M: Chaque 1
1	0	1	DKC134-0074	Line #2 D2202-3 Side Pod Base B121872 ✓ Référence DKA362-0016 DWG: REV. G Lot # 63050	U of M: Chaque 1

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

7 juillet

Client : DART US DART AEROSPACE
Numéro Job : 63009
Numéro : 4347
Numéro B.A. :
Cette fois : 2014-07-04 No. :
Prsht Rev. : NC
Prem. fois : --- Type :
Job précédente : 62083Nom Dessin : UTILITY POD LID
Numéro Article : DKC134-0073
Numéro Dessin : D2202
Projet Numéro : DK-362
Révision dessin : G
Matériel : Resine Darakane 470-36/411/510
Date Dûe : 2014-08-11 Qté: 1 Ud UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de Pièce Client: D2202-1

COPIE

Process Sheet Rév.: 03 Ajout de la IF134-0008 à la
séquence 35.0.

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-45827-1

2.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 9/07/14 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total: 1.250 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-45003-2

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0 GEL COAT Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Appliquer le gel coat selon IG 0019.

Date: 9/07/14 Sceau:



Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63009

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-49418-1

7.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)
Tissu à délaminer Release ply B

de Lot: N/A

8.0	AAC1608	5oz plain weave Kevlar 50" wide roll
-----	---------	--------------------------------------

Comment Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)
5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-42765-1

9.0	AAC1887	Wrightlon 5200 Bleu P3
-----	---------	------------------------

Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)
Wrightlon 5200 Bleu P3

de Lot: N/A

10.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

11.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Comment Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

13.0	TAILLAGE	Faire le taillage du matériel
------	----------	-------------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply
Film Durisol P-3
Feutre de drainage 6m
Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Date: Vendredi, 2014-07-04 09:35:51

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 63009

Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération:

Description :

Date: 08-07-14 Sceau:



14.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-46397-1

15.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

16.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid :

1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Date: 9/07/14 Sceau:



17.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar)
de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350
Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre
avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin
)

Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar)

Date: 9/07/14 Sceau:



18.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher 4 heures minimum

Date: 9/07/14 Sceau:



Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

Cliant: DART US DART AEROSPACE
Numéro Job: 63009

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

19.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-46397-1

20.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total: 0.0135 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 DKC134-0022 D2202-101 Foam Core (Utility Pod Lid)

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
D2202-101 Foam Core (Utility Pod Lid) N° de Job: 63014

22.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst
DDM-9 par quantité de résine.

Date: 9/07/14 Sceau:



23.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0022 selon IG 0105.

Date: 9/07/14 Sceau:



24.0 AAC1611 Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)
Polybond B46F N° de Lot: 1-38789-1

25.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG
0033.

Date: 10/07/14 Sceau:



26.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63009

Nom Dessin: UTILITY POD LID
Numéro: DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 8:30 Heure Fin Curing: 9:45

Date: 10/07/14 sceau:



27.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-46397-1

28.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod
Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

Date: 11/07/14 Sceau:



30.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)

Recommencer pour le dernier plis. (un pli de 9 oz)

Date: 11/07/14 Sceau:



Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63009

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

31.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher 4 heures minimum.

Heure début Curing: 10:30

Heure Fin Curing: 8:00

Date: 11/07/14 Sceau:



32.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la pièce

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.

Date: 14-02-14 Sceau:



33.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1

34.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munie d'une aiguille de la résine au endroit où il y a des bulles d'air.

Corriger les imperfection de surface à l'aide du "Filler" P15-3 selon IG 0043

Laisser sécher jusqu'au lendemain.

Date: 05-08-14 Sceau:



Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63009

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le trimage du Pod Lid selon la IF 134-0008.

Date: 16/07/14 Sceau:



36.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-46475-2

37.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 11

38.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Date: 05-08-14 Sceau:



Fiche de Mélange: 6640

39.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le sablage au grit 180 de la surface primée pour enlever les imperfections restantes.

Date: 7/08/14 Sceau:



40.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-46475-2

41.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-46475-2

42.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Date: 07-08-14 Sceau:



Fiche de Mélange: 6640

Date: Vendredi, 2014-07-04 09:35:51
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63009

Nom Dessin: UTILITY POD LID
Numéro DKC134-0073

Numéro Job:



Séq.: Machine ou Opération: Description :

43.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Refusé 08/08/14



Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 20-07-14 Sceau:



44.0 EMBAL / ENTREPO Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 14-8-14 Sceau: 4451 SM

Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE
Numéro Job : 63050
Numéro : 4346
Numéro B.A. :
Cette fois : 2014-07-08 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 62081Nom Dessin : UTILITY POD BASE
Numéro Article : DKC134-0074
Numéro Dessin : D2202
Projet Numéro : DK-362
Révision dessin : G
Matériel : Resine Darakane 470-36/411/510
Date Dûe : 2014-07-15 Qté: 1 Ud UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de Pièce Client: D2202-3

COPIE

Process Sheet Rév.: 02 changer l'araldite 2043 pour le
2012, AAC1885 était AC0883, AAC1887 était AC0884.

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-45827-1

2.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 4/08/14 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 0.125 UNITE(s)/Unit Total : 0.125 UNITE(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 4701610AA

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst
par quantité de résine

Date: 4/08/14 Sceau:



Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63050

Nom Dessin: UTILITY POD BASE
Numéro DKC134-0074

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 GEL COAT Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Faire l'application du gel coat selon IG 0019.

Date: 4/08/14 Sceau:



7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-49418-1

8.0 AAC1608 5oz plain weave Kevlar 50" wide roll

Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)

5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-42765-1

9.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)

Tissu à délaminer Release ply B

de Lot: N/A

10.0 AAC1887 Wrightlon 5200 Bleu P3

Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)

Wrightlon 5200 Bleu P3

de Lot: N/A

11.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

12.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 42.63 VERGE(s)/Unit Total : 42.63 VERGE(s)

13.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

14.0 TAILLAGE Faire le taillage du matériel



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les trois plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 63050

Numéro DKC134-0074

Numéro Job:



Séq.: Machine ou Opération: Description :

Peel Ply
Feutre de drainage 6mm
Stretchlon 200
5200 Wrightlon

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Date: 10/07/14 Sceau:



15.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 LITRE(s)/Unit Total: 2.500 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-46397-1

16.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

17.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid :
1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Date: 4/08/14 Sceau:



18.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar)
de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350
Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre
avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin
)












Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar)

Date: 4/08/14 Sceau:

















Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE	Nom Dessin: UTILITY POD BASE	
Numéro Job: 63050	Numéro DKC134-0074	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
19.0	BAGGING	Faire le bagging sur la pièce
		
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la poche à vide selon IG 0012 Laisser sécher pendant 4 heures minimum. Heure début curing: 1:00 Heure fin curing: 8:00 Date: 4/08/14 Sceau:  		
20.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.400 LITRE(s)/Unit Total : 0.400 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-46397-1		
21.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1		
22.0	PREP-GENERAL	Préparation du matériel
		
Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst DDM-9 par quantité de résine. Date: 4/08/14 Sceau: 		
23.0	DKC134-0021	D2202-103 Foam Core (Utility pod Base)
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D2202-103 Foam Core (Utility pod Base) N° de Job: 63013		
24.0	ASSEMBLAGE	Assemblage mécanique
		
Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Sceller le foam core selon IG 0105. Date: 4/08/14 Sceau: 		
25.0	AAC1611	Polybond B46F
Comment Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) Polybond B46F N° de Lot: 1-40597-1		

Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: UTILITY POD BASE	
Numéro Job: 63050		Numéro DKC134-0074	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
26.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033			
Date: <u>5/08/14</u> Sceau:  			
27.0	BAGGING	Faire le bagging sur la pièce	
			
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la poche à vide selon IG 0012.			
Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.			
Heure début Curing: <u>9:00</u> Heure Fin Curing: <u>10:30</u>			
Date: <u>5/08/14</u> sceau:  			
28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 2.500 LITRE(s)/Unit Total : 2.500 LITRE(s)			
Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-46397-1</u>			
29.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)			
Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
30.0	PREP-GENERAL	Préparation du matériel	
			
Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod			
Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.			
Date: <u>6/08/14</u> Sceau: 			
31.0	LAMINAGE	Faire le laminage	
			
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Faire le laminage des trois derniers plis de tissu (2 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:			

Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE Nom Dessin: UTILITY POD BASE
Numéro Job: 63050 Numéro: DKC134-0074



Numéro Job:



Séq.: Machine ou Opération: Description :

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350
Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule,
suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au
besoin)

Recommencer pour les deux autres plis. (un pli de 5 oz Kevlar et un pli de 9 oz)

Date: 6/08/14 Sceau: 44/19 J.L.  

32.0 BAGGING Faire le bagging sur la pièce





Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide sur le moule N° DT8002, selon IG 0012.

Laisser sécher 4 heures minimum.

Heure début Curing: 10:30 Heure Fin Curing: 8:00

Date: 6/08/14 Sceau: 44/19 J.L.  



33.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager
la pièce.

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod
à l'aide du manche d'un tournevis.

Date: 7/08/14 Sceau:  

34.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1

35.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille
de la résine au endroit où il y a des bulles d'air.

Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63050

Nom Dessin: UTILITY POD BASE
Numéro: DKC134-0074

Numéro Job:



Séq.: Machine ou Opération: Description :

Corriger les imperfections de surface à l'aide du "Filler" P15-3 selon IG 0043.

Laisser sécher jusqu'au lendemain.

Date: 8/08/14

Sceau:



36.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le trimage du Pod Base selon le dessin Page 2 de 4 Détail B.

Date: 7/08/14

Sceau:



37.0

AAC1615

D3001-1 Doubler (Pod Base D2002-3)

Comment Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)

D3001-1 Doubler (Pod Base D2002-3)

N° de Lot:

4693510AA

38.0

AAC0102

Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)

Colle Araldite N° 2012 (50ml)

N° de Lot:

04646610AA

39.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

À l'aide de l'adhésif Araldite 2012 coller les trois doubler N° D3001-1 selon le dessin & selon IG 0058.

Venir faire trois petite poche à vide localisées sur les trois doubliers (Stretchlon 200 seulement pas besoin de perforé, ni de airweave, ni de feutre de drainage, ni de peel ply.

)

Date: 7/08/14

Sceau:



40.0

AAC0102

Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)

Colle Araldite N° 2012 (50ml)

N° de Lot:

04646610AA

41.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirer les trois poches à vide et faire un joint tout autour des trois doubliers à l'aide d'Araldite 2012 et laisser sécher jusqu'au lendemain.

Date: 8/08/14

Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63050

Nom Dessin: UTILITY POD BASE
Numéro: DKC134-0074

Numéro Job:



Séq.: Machine ou Opération: Description :

42.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.4333 UNITE(s)/Unit Total: 0.4333 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-46475-2

43.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-46475-2

44.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 75.0000Min Total Run: 1.2500Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008.

Date: 8/08/14 Sceau: 20 N° fiche de Mélange: 6642

45.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le sablage du primer batisseur selon IG 0008.

Date: 11/08/14 Sceau: 73 56 12-08-14 73

46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.2217 UNITE(s)/Unit Total: 0.2217 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-46475-2

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-4663-3

48.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008.

Date: 13/08/14 Sceau: 5, D4400 N° fiche de Mélange: 6644

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 14/08/14 Sceau: 0A-3

Date: Mardi, 2014-07-08 08:39:41
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 63050

Nom Dessin: UTILITY POD BASE
Numéro: DKC134-0074

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date: 14-8-14 Sceau: 4451 SM